

# Work Order ID 67782

Wednesday, March 30, 2011 11:32:47 AM



Page 1

Item ID: D3660-1

Accept



Setup Start



Revision ID:

Stop



Item Name: CUFF

Start Date: 3/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

*M*

Date: *11-03-30*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3660

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 7.300 " long

*val 11-4-12*

*6*

110

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per folio FA 708 & DWG D3660,

FOLIO REV: *12*

DWG REV: *13*

2-Deburr as required

*val 11-4-12*

*6*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*val 11-4-12*

*9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67782**

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Item ID: D3660-1

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Start Date: 3/30/2011 Start Qty: 6.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

OK 11/04/13



QC

Memo

0.00

Quality Control

6 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 BR 11-4-13

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 d 11/04/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 67782**

Wednesday, March 30, 2011 11:32:47 AM



Page 3

Item ID: D3660-1

Accept



Setup Start



Revision ID:

Stop



Item Name: CUFF

Start Date: 3/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 177

0.00



Packaging

Memo

0.00

Packaging

11/4/13 1/6

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13 MF  
11-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B:			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 30, 2011 11:32:53 AM

Page 1

Work Order ID: 67782

Parent Item: D3660-1

Parent Item Name: CUFF



Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM  
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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~~D6008-180~~

Manufactured

No

100

Each

23.0000

0.056

0.353684



Crosstube Extrusion



*11-4-12*

*D6008-132*

*11-04-19*

Location

LG

46779

59249

*50892*

*\* not pulled*

Loc Qty

23

8

15

Loc Code

*3.65*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	67782
<b>Description:</b> Cuff		<b>Part Number:</b>	D3660-1
<b>Inspection Dwg:</b> D3660	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.950	+/-0.010	3.950	/		129.02	
3.075	+/-0.010	3.075	/			
2.500	+/-0.010	2.500	/			
1.700	+/-0.010	1.700	/			
0.800	+/-0.010	.800	/			
0.438	+/-0.010	.439	/			
Ø0.128	+0.005/-0.001	.128	/			
Ø0.230 x 100°	+/-0.010 x 0.5°	.235 x 100	/			
Ø0.386	+0.005/-0.000	.390	/			
Ø2.990	+0.005/-0.000	2.993	/			
Ø2.695	+0.005/-0.000	2.699	/			
2.050	+/-0.005	2.050	/			

<b>Measured by:</b> <i>MD</i>	<b>Audited by:</b> <i>MD</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-4-12	<b>Date:</b> 11/04/13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.12	New Issue	KJ/DD	<i>MD</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

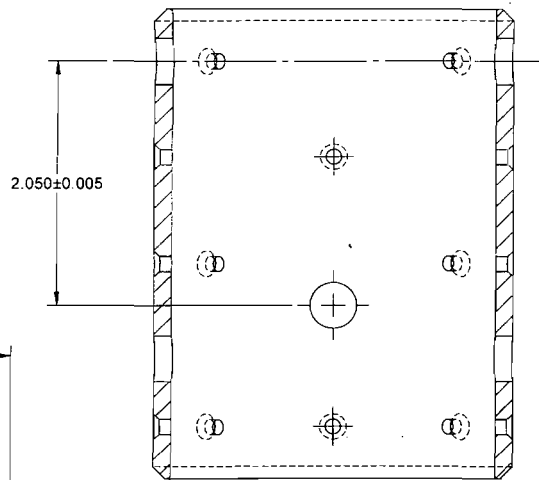
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

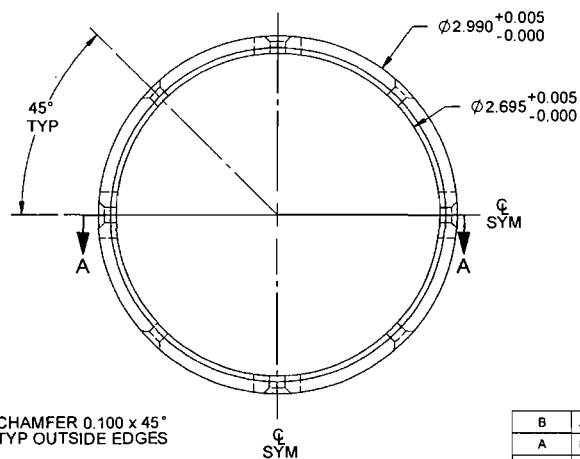
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39 1/2  
= 196  
128  
= 128  
0.26

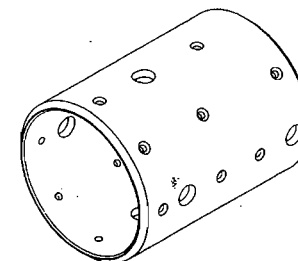


R0.032 TYP  
INSIDE EDGES



CHAMFER 0.100 x 45°  
TYP OUTSIDE EDGES

### D3660-1 CUFF



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67782

PL 11-03-3C

DRILL #30 ( $\phi 0.128$  REF)  
C'SINK  $\phi 0.230 \times 100$   
TYP 22 PLACES

$\phi 0.386^{+0.005}_{-0.000}$   
HOLE TO BE ALIGNED  
WITHIN  $\pm 0.001$  OF HOLE  
ON OTHER SIDE OF CUFF,  
TYP 6 PLACES

#### NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)  
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

B	ADD $\phi 0.128$ & $\phi 0.386$ HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.03.03		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3660</b>	REV. B
TITLE <b>CUFF</b>	SCALE NTS
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